



**!!!! WARNING !!!!**



**WELDING FUMES AND GASES CAN BE DANGEROUS TO YOUR HEALTH.**

**BEFORE USING THIS PRODUCT THE WELDER (END-USER) MUST READ AND UNDERSTAND THE COMPLETE PRODUCT WARNING LABEL AND MATERIAL SAFETY DATA SHEET (MSDS).**

**THE MATERIAL SAFETY DATA SHEET (MSDS) WHICH OUTLINES THE POTENTIAL HEALTH HAZARDS AND SAFETY INFORMATION RELATED TO THIS PRODUCT CAN BE DOWNLOADED FROM THE MSDS PORTION OF THIS WEBSITE. IT IS ALSO AVAILABLE FROM YOUR EMPLOYER AND WELDING SUPPLY DISTRIBUTOR.**

**DO NOT PROCEED WITH USE OF THIS PRODUCT UNTIL YOU READ AND UNDERSTAND THE MATERIAL SAFETY DATA SHEET (MSDS) AND PRODUCT WARNING STATEMENT.**

**BE SURE TO CONSULT THE LATEST VERSION OF THE MSDS.**

**SEE THE PRODUCT WARNING LABEL AND MSDS FOR COMPLETE WARNING INFORMATION.**



# **CROWN ALLOYS**

## **COMPANY**

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## **Crown Sil 55 - Sil 55FC**

**Cadmium Free High Silver Alloy**

### **Typical Applications:**

Crown 56% silver alloy is safe for use on food handling equipment. It is used by hospitals, dairies, bakeries and also in tool and die work. It can be used on all ferrous and non-ferrous metals except the white metals (aluminum and magnesium). This 56% silver alloy melts at a lower temperature than the 45% silver alloy and is therefore well suited for brazing stainless steel, nickel or nickel alloys where stress cracking can occur at higher temperatures. 56% silver alloys also provide good color match on stainless steels, nickel and nickel alloys due to its whitish color. The **Crown Sil 55FC** is pre-fluxed with just the right amount of flux. This very convenient alloy requires no dipping or preparatory work. **Crown Sil 55 and Sil 55FC** have a maximum recommended operating temperature of 400°F for continued service and up to 600°F for intermittent service.

### **Specifications:**

AWS A 5.8

BAG-7

➤ Silver	55.0-57.0%
➤ Copper	21.0-23.0%
➤ Zinc	15.0-19.0%
➤ Tin	4.5-5.5%
➤ Tensile Strength	66,000 PSI
➤ Solidus	1145°F
➤ Liquidus	1200°F
➤ Brazing Range	1205-1400°F

### **Procedure:**

Clean work surface. Joint clearances of 0.001 to 0.005 inches are recommended for proper capillary action. Remove dirt, grease, and rust from joint area. When using the bare **Sil 55**, apply **Crown 45 Flux** to joint. Heat joint until flux liquefies and apply silver. Keep torch moving around joint until silver flows out completely. When using **Crown Sil 55FC**, melt off a little flux onto work first and follow procedure as above.

### **Sizes:**

SIL 55:

3/64 x coil (bare)

1/16 x coil & 18" cut length (bare)

3/32 x coil & 18" cut length (bare)

SIL 55 FC:

1/16 x 18" cut length (flux coated)

3/32 x 18" cut length (flux coated)